

# Work Order ID 149315

\*149315\*

AMOD

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July 22, 2016 2:32:23 PM

Item ID: D2012-107 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Clevis  
 Start Date: 9/28/2016 Start Qty: 46.00 \*46\* Cust Item ID:  
 Required Date: 9/30/2016 Req'd Qty: 46.00 \*46\* Customer:  
 Reference:

Approvals: Process Plan: 5H Date: 7/25/16 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description                                                                       | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|------------------------------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| <u>Draw Nbr</u>                | <u>Revision Nbr</u>                                                                            |                      |         |        |              |               |               |                  |                |
| D2012-107                      | Rev C                                                                                          |                      |         |        |              |               |               |                  |                |
| 100                            | FLOW WATER JET                                                                                 | 0.00                 |         |        |              |               |               |                  |                |
| *100*                          |                                                                                                |                      |         |        |              |               |               |                  |                |
| Waterjet                       | Memo                                                                                           | 0.31                 |         |        |              |               |               |                  |                |
| FLOW CNC Waterjet              | 1-Cut as per Dwg D2012-107<br>Dwg Rev: <u>C</u><br>Prog Rev: <u>C</u><br>2-Deburr if necessary |                      |         |        |              |               |               |                  |                |
| 110                            | QC2- Inspect parts off machine FAI/FAIB                                                        | 0.00                 |         |        |              |               |               |                  |                |
| *110*                          |                                                                                                |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                                                                           | 0.08                 |         |        |              |               |               |                  |                |
| Quality Control                |                                                                                                |                      |         |        |              |               |               |                  |                |
| 120                            | QC8- Inspect parts - second check                                                              | 0.00                 |         |        |              |               |               |                  |                |
| *120*                          |                                                                                                |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                                                                           | 0.15                 |         |        |              |               |               |                  |                |
| Quality Control                |                                                                                                |                      |         |        |              |               |               |                  |                |

53 PR 2016/07/29  
53 PR 2016/07/29  
53 16-08-02 DAS  
9  
9-89

# Work Order ID 149315

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Item ID: D2012-107 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Clevis  
Start Date: 9/28/2016 Start Qty: 46.00 **\*46\*** Cust Item ID:  
Required Date: 9/30/2016 Req'd Qty: 46.00 **\*46\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                            | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number  | Insp.<br>Stamp    |
|--------------------------------|-----------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|-------------------|-------------------|
| 130                            | NC BRAKE                                            | 0.08                 |         |        |              |               |               |                   |                   |
| <b>*130*</b>                   |                                                     |                      |         |        |              | 53x           |               |                   | 16/08/04          |
| Brake NC                       | Memo                                                | 0.77                 |         |        |              |               |               |                   |                   |
| Brake NC                       | Form on press using DT9511 as per Dwg D2012-107     |                      |         |        |              |               |               |                   |                   |
|                                |                                                     |                      |         |        |              |               |               | DAS<br>43<br>9-89 |                   |
| 140                            | QC5- Inspect part completeness to step on W/O       | 0.00                 |         |        |              |               |               |                   |                   |
| <b>*140*</b>                   |                                                     |                      |         |        |              | 53x           |               |                   | AUG 04 2016       |
| QC                             | Memo                                                | 0.15                 |         |        |              |               |               |                   |                   |
| Quality Control                |                                                     |                      |         |        |              |               |               |                   |                   |
| 150                            | Identify as per dwg & Stock Location: <u>WWA 04</u> | 0.00                 |         |        |              |               |               |                   |                   |
| <b>*150*</b>                   |                                                     |                      |         |        |              | 53            |               |                   | DAS<br>43<br>9-89 |
| Packaging                      | Memo                                                | 0.08                 |         |        |              |               |               |                   | AUG 04 2016       |
| Packaging                      | LOCATION : WA004                                    |                      |         |        |              |               |               |                   |                   |

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Item ID: D2012-107

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Clevis

Start Date: 9/28/2016 Start Qty: 46.00

**\*46\***

Cust Item ID:

Required Date: 9/30/2016 Req'd Qty: 46.00

**\*46\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21 - Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.77

DAS  
21

AUG 04 2016

9-89

gem

16/08/04

Quality Control

# Picklist Print

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Work Order ID: 149315

**\*149315\***

Parent Item: D2012-107

**\*D2012-107\***

Parent Item Name: Clevis

Start Date: 9/28/2016

Required Date: 9/30/2016

Start Qty: 46.00

Required Qty: 46.00

Comments: IPP: D 01.11.08 Re-format, Drawing to Rev. CSM  
IPP Rev:E Now on Waterjet 06-06-13 JLM

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M304S16GA

Purchased

No

110

sf

90.2498

0.016

0.774737

**\*M304S16GA\***

**\*\***

*PR 2016/07/29*

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT010

73.75

m134677

4.27

m134982

5.48

m135061

64

TPI

16.499794

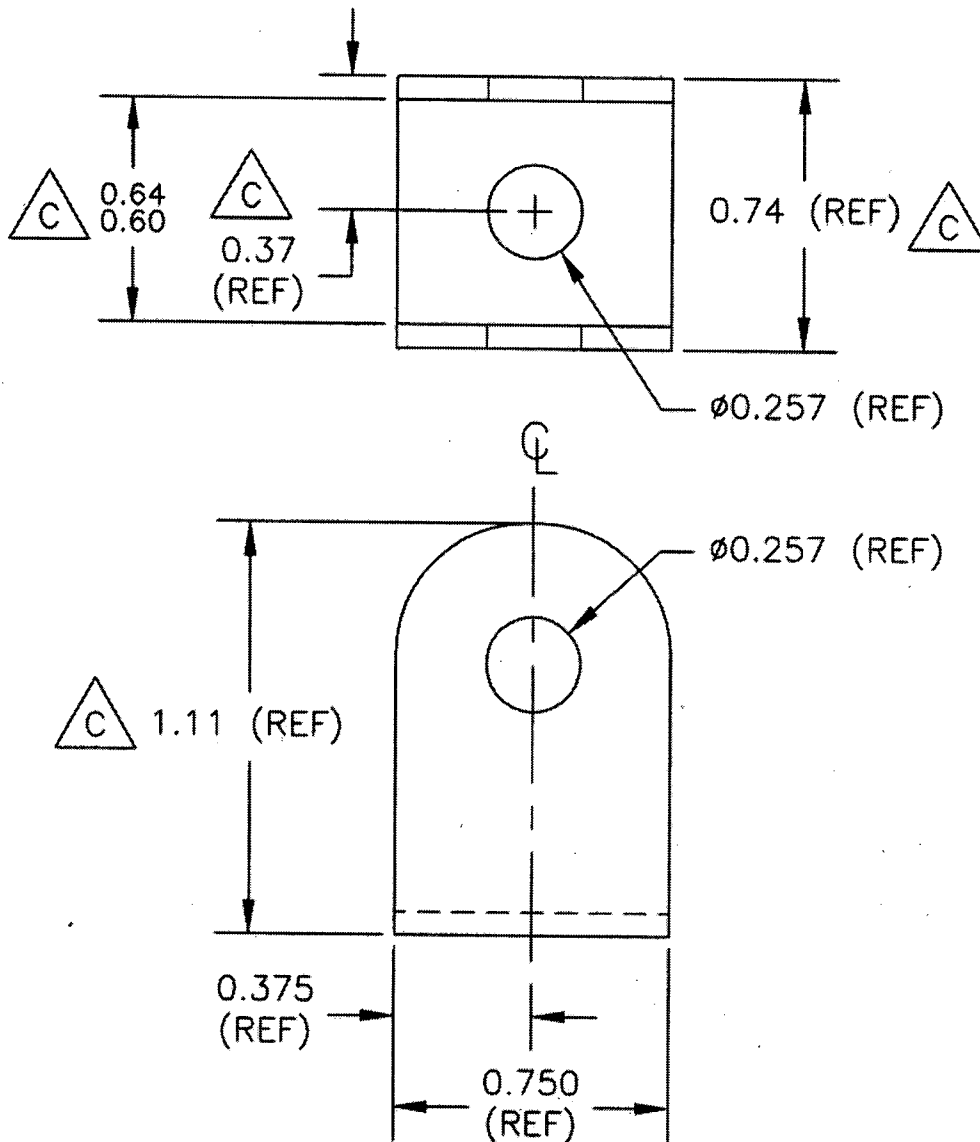
m134604

16.499794



|                               |                                |                                                   |                        |
|-------------------------------|--------------------------------|---------------------------------------------------|------------------------|
| DESIGN<br>BW                  | DRAWN BY<br>RF                 | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2012-107                          | REV. C<br>SHEET 1 OF 2 |
| DATE<br>99.12.20              |                                | TITLE<br>CLEVIS                                   | SCALE<br>2:1           |
| A                             | 94.10.27                       | NEW ISSUE                                         |                        |
| B                             | 99.04.30                       | ADD FLAT PATTERN                                  |                        |
| C                             | 99.12.20                       | 0.74 WAS 0.680                                    |                        |

RELEASED  
00.01.04 DS

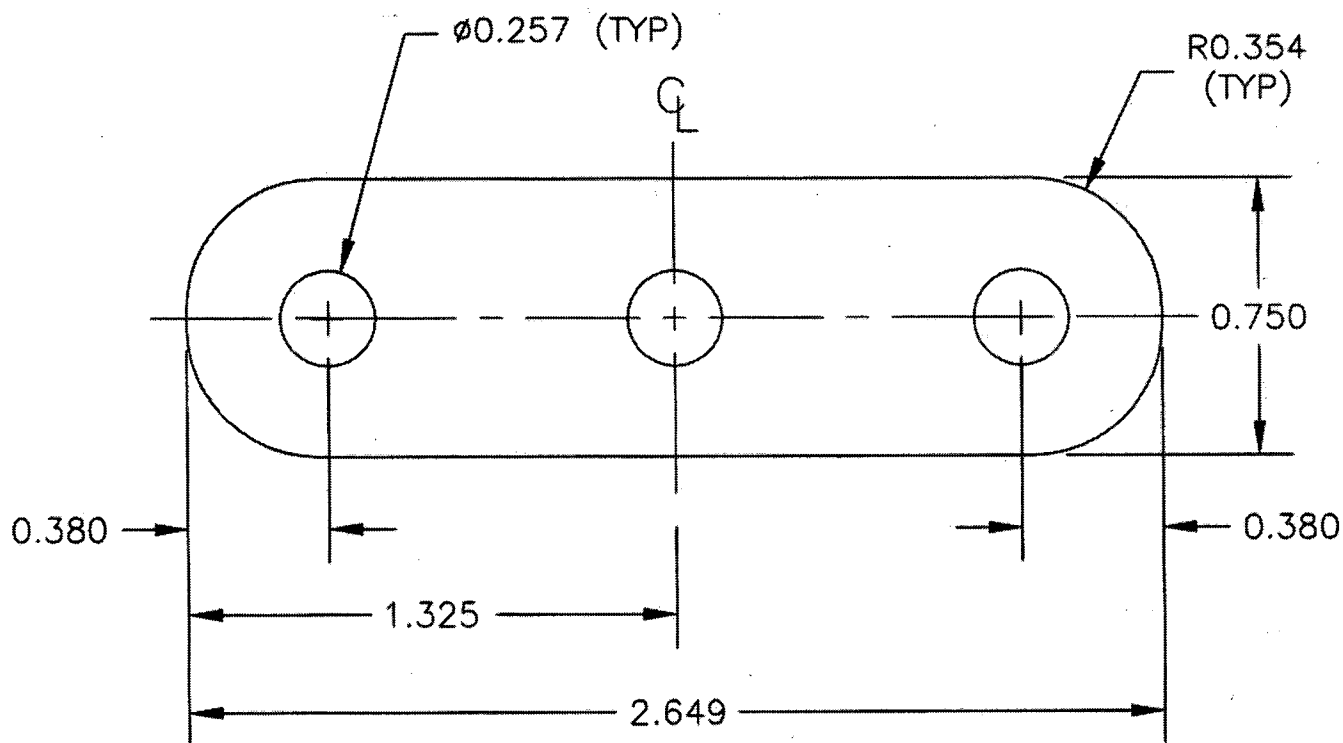


MATERIAL: AISI 304/316 SS 0.063 THICK  
USE 0.032 BEND RADIUS  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES



|                  |                |                                                   |                        |
|------------------|----------------|---------------------------------------------------|------------------------|
| DESIGN<br>BW     | DRAWN BY<br>RF | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>#     | APPROVED<br>#  | DRAWING NO.<br>D2012-107                          | REV. C<br>SHEET 2 OF 2 |
| DATE<br>99.12.20 |                | TITLE<br>CLEVIS                                   | SCALE<br>2:1           |

RELEASED  
00-01-04 DS



D2012-107 FLAT PATTERN

MATERIAL: AISI 304/316 SS 0.063 THICK  
TOLERANCES ARE DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

